

**Work Order ID 69146**

Tuesday, May 03, 2011 11:43:56 AM



Page 1

Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*H*Date: *1-05-3*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

*JJ for BG 11-9-14**B69-146*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

11/05/30

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: ☐ M117884

86 11/08/29

12-Grind welds flush as per Dwg D2750

OK 11/08/31

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/08/31

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/08/31

W/O:		WORK ORDER CHANGES					
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\_\_\_\_\_

*Tuesday, May 03, 2011 11:43:56 AM*

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291

batch: M11B393

exp. date: 12/05/15

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R ☐ ☐ ☐ Aluminum Rod

batch: M11B736

BE 11/09/07

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

DL 11/08/31

BB 11/09/07

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Stop



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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S u l o r l o s

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u l o r l o s

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

IX O M - 11/09/08

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
	Memo								
	START TIME: 7:30	0.00							
	OVEN TEMPERATURE: 320	0.00							
	FINISH TIME: 8:00								
210	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo								
	Inspect for foreign object per QSI 024								

*Handwritten signature: H. J. M. 11/09/12*

*Handwritten signature: 1. J. M. 11/09/12*

*Handwritten note: M 117745*

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
	1-Install inserts as per dwg D2750								
	2-assemble o-ring as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>11114342</u>								
	3-Assemble tube hardware as per dwg D2750 sikaflex batch: <u>1118393 12/01</u>								
	4-Inspect For Foreign Objects								
	5-Spray inside of tube with "LPS-3" batch: <u>11/12</u>								
	6-Install blade fitting D3488-041, wearshoe SIKA FLEX 241 BATCH: <u>1118393</u> EXP DATE: <u>12/01</u>								
	7-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>11114342</u>								
	8-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u>								

1 0 111091121

W/O:		WORK ORDER CHANGES					
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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 4/29/12

250



Packaging

Packaging

Pick Kit

0.00

0.00

Memo

11/9/13

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

Memo

S 5/16/16

④

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-014								
280 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/11 689

11/9/11 194

MF  
11-09-18

W/O:		WORK ORDER CHANGES					
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Tuesday, May 03, 2011 11:36:23 AM

Page 1

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:I 05.12.08 Rearranged procedure steps EC  
 IPP Rev:J 06.03.30 Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

70823

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

23.0000

1

1



Extrusion Bent



1

11/08/30

Location

Loc Qty

Loc Code

LG

72153

23

66874

1

66875

8

68137

10

68138

4

D2739

Manufactured

No

160

Each

14.0000

1

1



350 I Beam



1

11/08/30

70823

Location

Loc Qty

Loc Code

LG

14

67785

2

68285

6

68286

6

D2743

Manufactured

No

160

Each

187.0000

8

8



Crossbolt Spacer



BE 11/09/07

271839

Location

Loc Qty

Loc Code

LG001

187

67766

123

68251

64

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

160

Each

37.0000

1

1



Cap



BE 11/08/29  
B 70881 ✓

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

D3490-1

Manufactured No

160

Each

93.0000

4

4



Cross Bolt Spacer



BE 11/09/07  
B 69823 \*4

Location

Loc Qty

Loc Code

LG

91

67773

31

68105

60

LG001

2

62450

2

D3490-5

Manufactured No

160

Each

74.0000

4

4



Cross Bolt Spacer



BE 11/09/07

Location

Loc Qty

Loc Code

LG001

74

46490

18

59230

56

ALS4-1032-225

Purchased No

230

Each

1,069.000

38

38



Insert



11/09/12

Location

Loc Qty

Loc Code

FP-B

28

110768

28

ST282

1041

110768

1041

M111581

x38

W/O:		WORK ORDER CHANGES					
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Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,332.000 34 34



Bolt



Handwritten: 34 1109112

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1325	
115422	49	
116419	376	
116549	100	
117343	500	
117508	300	

Handwritten: x34

AN3C6A Purchased No 230 Each 300.0000 4 4



BOLT



Handwritten: 4 1109112

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	299	
111982	2	
116419	47	
116549	50	
116704	100	
117514	100	

Handwritten: 11112688

Handwritten: 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:36:23 AM

Work Order ID: 69146

Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 5/3/2011



Required Date: 5/17/2011

Start Qty: 1.00



Required Qty: 1.00



AN6C44A Purchased No 230 Each 86.0000 4 4  
  
 BOLT  M 1109/12

Location	Loc Qty	Loc Code
FG	2	M 117950
103964	2	X4
ST344	84	
116874	4	
117407	80	

AN8C35A Purchased No 230 Each 70.0000 1 1  
  
 BOLT  M 1109/12

Location	Loc Qty	Loc Code
FP	40	
117511	40	X1
FP-A	30	
115960	7	
116874	23	

AN960C10L NAS1149C0332 Purchased No 230 Each 0.0000 38 38  
  
 washer M 111835  (x38) M 1109/12

AN960C816L Purchased No 230 Each 0.0000 1 1  
  
 WASHER NAS1149C0832R / M 1114915  (x1) M 1109/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:36:24 AM

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 214.0000 8 8



Bushing



Handwritten: MU 11/09/12

Location

Loc Qty

Loc Code

FP-A

214

B69529

Handwritten: x8

67764

13

68248

201

D3488-042 Manufactured No 230 Each 12.0000 1 1



Blade Fitting Assembly, RH



Handwritten: MU 11/09/12

Location

Loc Qty

Loc Code

FP008

12

B71833

Handwritten: x1

62003

4

65099

8

D3492-1 Manufactured No 230 Each 0.0000 8 8



Plug

B71836



Handwritten: (x8) MU 11/09/12

D3492-5 Manufactured No 230 Each 0.0000 8 8



Plug

B69533



Handwritten: (x8) MU 11/09/12

B72126

D3535-25 Manufactured No 230 Each 18.0000 1 1



Wearshoe



Handwritten: MU 11/09/12

Location

Loc Qty

Loc Code

FP018

18

B69743

Handwritten: x1

62233

1

65167

6

68353

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:36:24 AM

Work Order ID: 69146

Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 5/3/2011



Required Date: 5/17/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	37.0000	1	1
							<u>u109112</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	37	B70780
65903	11	
68351	26	

D3537-1	Manufactured	No	230	Each	39.0000	3	3
							<u>u109112</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	39	B70687
63313	2	
66135	33	
66935	4	

D3631-1	Manufactured	No	230	Each	500.0000	8	8
							<u>u109112</u>
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST072	500	
68062	500	

D3672-1	Manufactured	No	230	Each	1,379.000	8	8
							<u>u109112 PTO</u>
Phenolic Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	29	
52505	29	
ST074	1350	
64177	850	
66821	500	

Dart Aerospace Ltd

W/O: 69146		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/09/12	230	Assemble with "NAS1515H3L / M11336Z washers Permanu cut change	WJ HA	11/09/12 11.09.19	x14	W	S 11/09/19

Part No: D350-636-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Monday, September 12, 2011 9:52:09 AM

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1



Phenolic Washer

Manufactured No

230

Each

1,178.000

8

8

*already pulled  
A-ME 11-09-12*

Location

Loc Qty

Loc Code

ST074

1176

64177

180

66821

496

72229

500

ST077

2

52505

2

D3791-1



Wearplate

Manufactured No

230

Each

22.0000

1

1

*M 11/09/12*

Location

Loc Qty

Loc Code

FP017

10

62239

2

69282

8

FP17

12

72158

12

*VI*

D3793-1



Wearshoe

Manufactured No

230

Each

14.0000

1

1

*M 11/09/12*

Location

Loc Qty

Loc Code

FP018

14

70781

14

*VI*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 12, 2011 9:52:09 AM

Page 7

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

20.0000

1

1



Wearshoe



Handwritten: MU 1109/12

Location

Loc Qty

Loc Code

FP018

20

70813

8

72160

12

Handwritten: X1

D3794-1

Manufactured No

230 Each

20.0000

1

1



Gasket



Handwritten: MU 1109/12

Location

Loc Qty

Loc Code

FP010

20

70779

20

Handwritten: X1

D3794-3

Manufactured No

230 Each

11.0000

1

1



Gasket



Handwritten: MU 1109/12

Location

Loc Qty

Loc Code

FP018

11

70812

11

Handwritten: V1

MS21043-6

Purchased No

230 Each

569.0000

4

4



NUT



Handwritten: MU 1109/12

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

549

112314

339

117887

10

118384

200

Handwritten: V4

Monday, September 12, 2011 9:52:09 AM

Shop Packet Print

Page 7

# Picklist Print

Monday, September 12, 2011 9:52:09 AM

Page 8

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

117.0000

1

1



u 11/09/12

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

35

118077

35

ST303

81

115884

0

117423

1

118354

30

118614

50

x1

NAS1611-005

Purchased

No

230

Each

184.0000

8

8



u 11/09/12

O-RING

Location

Loc Qty

Loc Code

FP002

184

106099

79

114220

105

x8

NAS1611-010

Purchased

No

230

Each

226.0000

8

8



u 11/09/12

O-RING

Location

Loc Qty

Loc Code

FP

209

117460

8

118077

1

118612

200

FP-A

17

110915

14

115589

3

x8

Monday, September 12, 2011 9:52:10 AM

Shop Packet Print

Page 8

# Picklist Print

Monday, September 12, 2011 9:52:10 AM

Page 9

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

105.0000

2



BOLT

## Location

## Loc Qty

## Loc Code

ST344

5

117764

5

ST345

100

118045

50

118758

50

AN960JD816

NAS1149D0863J

Purchased

No

250

Each

0.0000

2



1/2" washer, Alum

D2741

Manufactured

No

250

Each

8.0000

1



Blade, 350 Skidtube

## Location

## Loc Qty

## Loc Code

ST466

8

69133

8

D3493-1

Manufactured

No

250

Each

89.0000

2



Washer

## Location

## Loc Qty

## Loc Code

ST062

89

70697

49

71846

40

# Picklist Print

Page 10

Monday, September 12, 2011 9:52:10 AM

Work Order ID: 69146

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

117.0000

2

2



NUT



5/18/13

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST293

35

118077

35

ST303

81

115884

0

117423

1

118354

30

118614

50

2

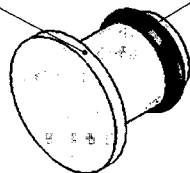
Monday, September 12, 2011 9:52:10 AM

Shop Packet Print

Page 10

D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 12144  
11-08-3

### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ C △ C △ C

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

UNDER REVIEW

02.04.21.02  
OK-ASS 08.11.12

DEO ATTACHED

RELEASED  
5.11.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047: UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3492	REV. C
TITLE PLUG	SHEET 1 OF 2
SCALE 2:1	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

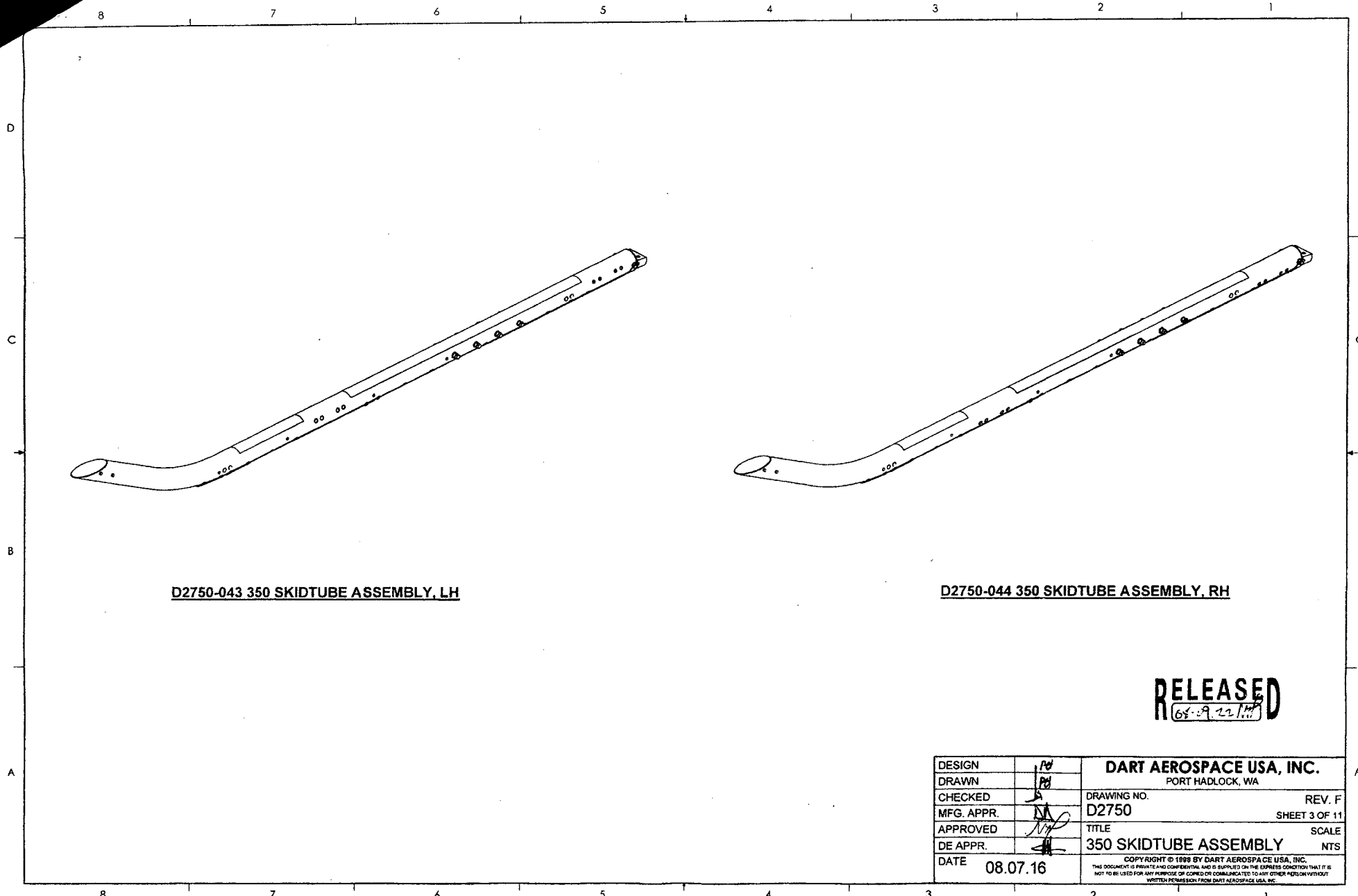
## GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED  
68 07 22 14

F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3532-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-6, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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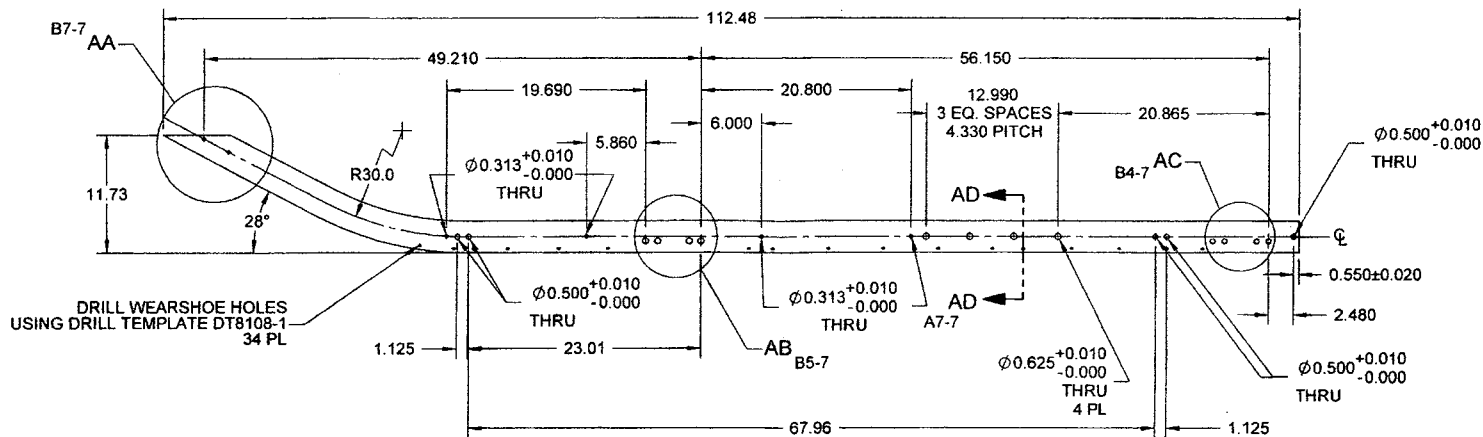


D2750-043 350 SKIDTUBE ASSEMBLY, LH

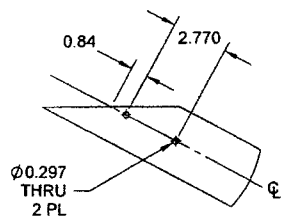
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED  
68-22-111

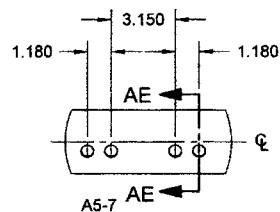
DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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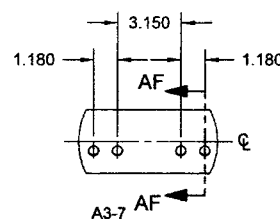
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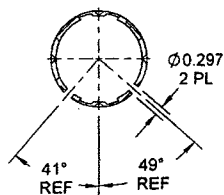
**DETAIL AA**  
SCALE 2X



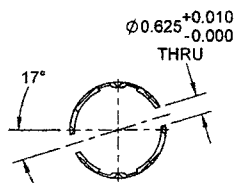
**DETAIL AB**  
SCALE 2X



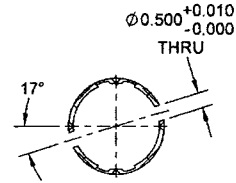
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



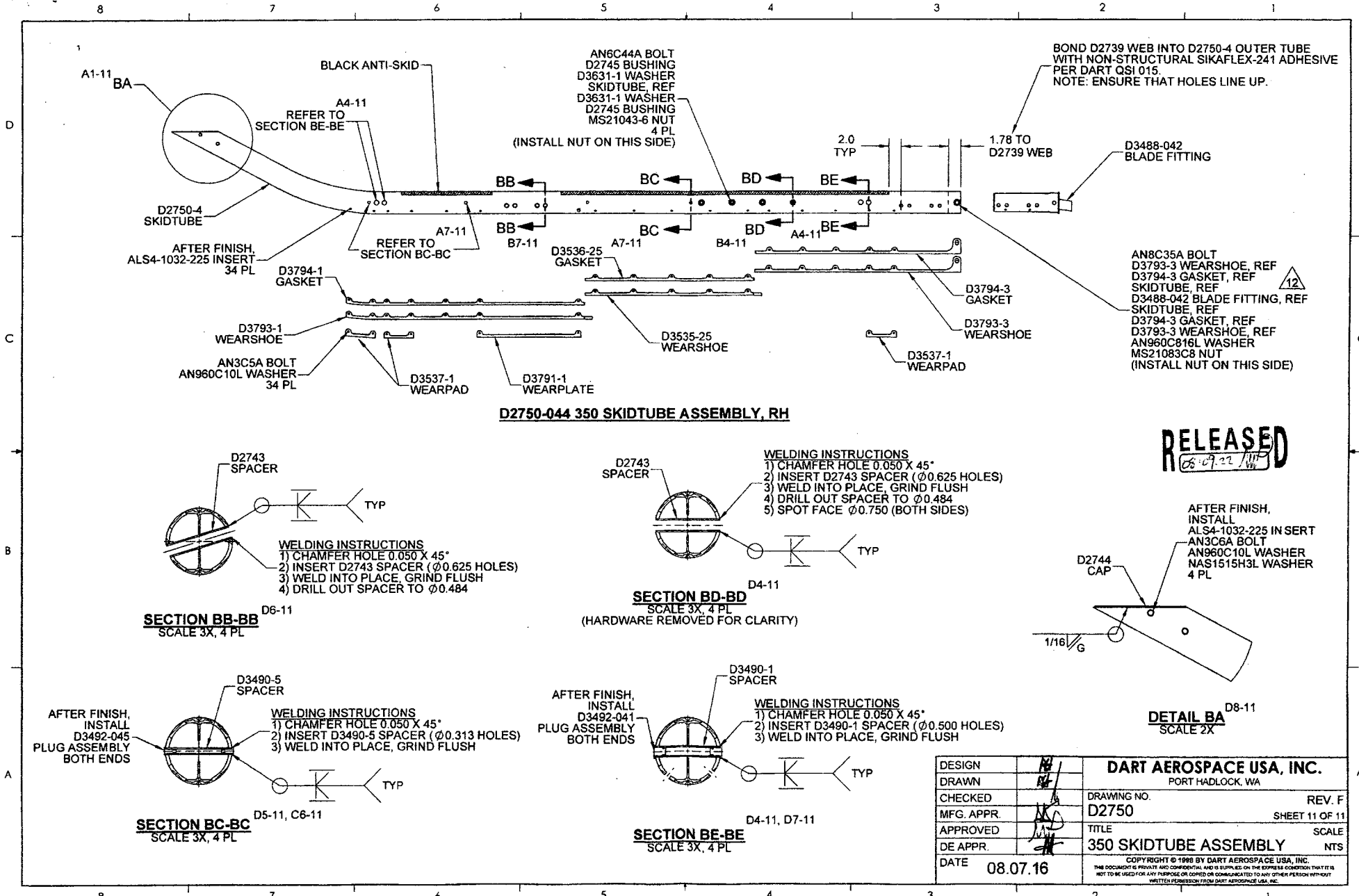
**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**

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DRAWN	APR	PORT HADLOCK, WA	
CHECKED	APR	DRAWING NO.	REV. F
MFG. APPR.	APR	<b>D2750</b>	SHEET 7 OF 11
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NO. 265

AWS D17.1.2001

QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 714270  
Part number: J 350 636 015  
Description: 350  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Sal Luy Date of Test Coupon 11.09.06  
Welder Barclay Elliott Date of Test Coupon 11.09.06

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries